



BETAMATE™ 73309F

Structural Adhesives

BETAMATE™ 73309F is a structural one-part, expandable, heat curing, epoxy adhesive. It is capable of bonding oily galvanized steels, cold rolled steel and aluminum without a primer. BETAMATE™ 73309F also has excellent wash off resistance.

BETAMATE™ 73309F can be used for general product assembly. Its ability to expand slightly (40-60% of its original volume) can assist in joining together parts of the body where tolerances can sometimes vary due to springback of the metal and where design tolerances are difficult to maintain. It provides better sealing than products that do not expand during bake and bonds well to oily substrates typically found in the body shop. It provides exceptional adhesion to steel and aluminum substrates with good corrosion resistance. It is designed with premier wash off resistance due to higher viscosity at higher temperatures typically seen in body shop wash tank environments.

Product information

Colour	Black
Solid content	≥99 %

Rheological properties

Steady state viscosity, rotational rheometer (450µm gap, 25mm plate, 3min dwell), 25°C, 3s-1	1000 Pa.s	DIN 54458
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Typical mechanical properties

Tensile Modulus	2500 MPa	ASTM D 638
Tensile Strength	39.0 MPa	ASTM D 412
Elongation at break	5 %	ASTM D 638
Lap shear strength	17.9 ^[2] MPa	DIN EN 1465
Peel strength, T-Peel	8.2 ^[2] N/mm	ISO 11339
Peel strength, Impact-Peel	21.8 ^[2] N/mm	ISO 11343

[1]: 30 minute 180C bake

[2]: 2mm Al 6022 cured 163C for 20 minutes

Thermal properties

Flash point	250 ^[3] °C	ASTM D 92
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[3]: Flash point tested up to 250C. testing beyond 250C upon request

Characteristics

Compatibility	Metals
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